

Work Order ID 67926

Monday, April 04, 2011 4:04:48 PM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MWF

Date:

11-04-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: *4114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

11.04.16 (12)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.04.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/15

Memo

0.00

70

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115128.

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 2:45

Oven Temperature: 300

Finish Time: 3:15

1 10-4-18.

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M11731 50.00

50.00

Memo

0.00

- 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
- 2- install label

1 4 10-4-19

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Accept



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Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

nl 11 04 19 ①

160

Identify as per dwg & Stock Location *G-A*

0.00



Packaging

Memo

0.00

Packaging

u/o
67920 (K)

GBA/04/12 ②

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/2011

MF

11-04-20

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Monday, April 04, 2011 4:04:45 PM




Page 1

Parent Item Name: Short Basket Lid Assembly (350)

Required Date: 4/22/2011

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1  Rib		Manufactured	No			100	Each	5.0000	2	2		11.04.14	
				<u>Location</u>									
				WA				5					
					67039			5					
✓ D4018-3  Rib		Manufactured	No			100	Each	1.0000	2	2		11.04.14	
				<u>Location</u>									
				WA005				1					
					67371			1					
✓ D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	12.0000	3	3		11.04.14	
				<u>Location</u>									
				WA005				12					
					65951			6					
					67040			6					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 3

Monday, April 04, 2011 4:04:45 PM

Work Order ID: 67926



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured

No

100

Each

2.0000

1

1



Data Plate



JS 11-04-16

Location

Loc Qty

Loc Code

WA005

2

65922

2

D2728-3

Manufactured

No

140

Each

0.0000

1



Dart Logo label



M115050 (x1)

(1x)

JS 11-04-19

Monday, April 04, 2011 4:04:46 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

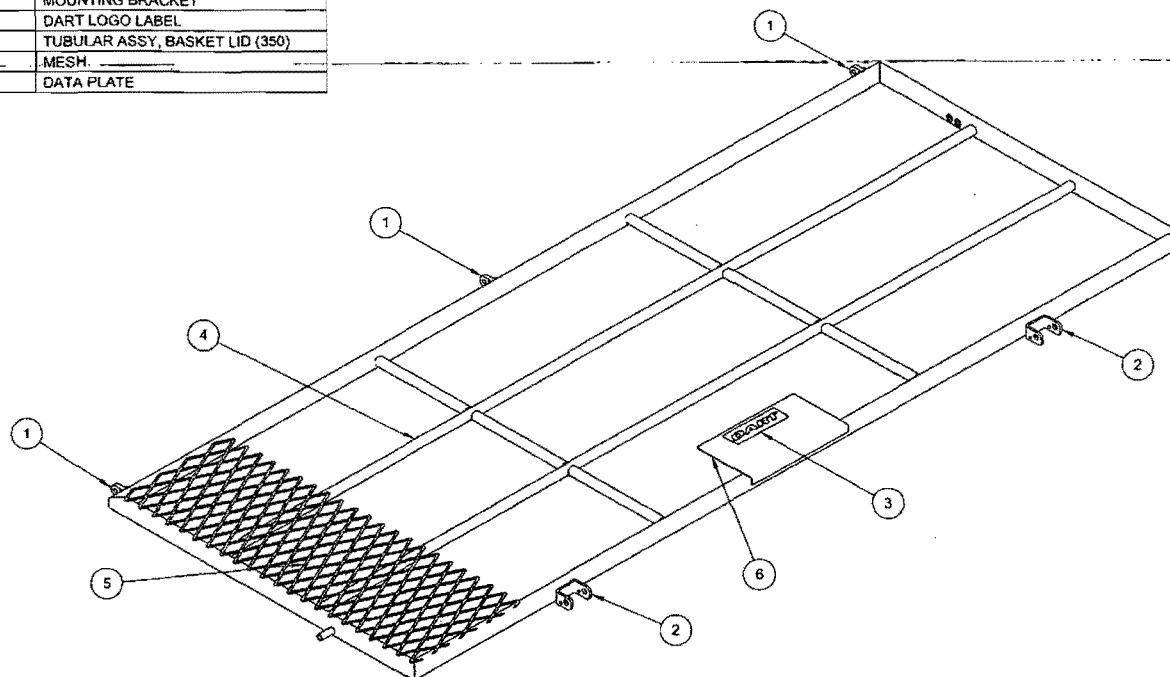
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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12
ECN 10-546

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2. NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED. WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4018

TITLE
SHORT BASKET LID ASSY (350)

REV. C
SHEET 1 OF 4

SCALE
NTS

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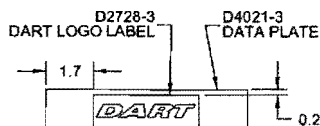
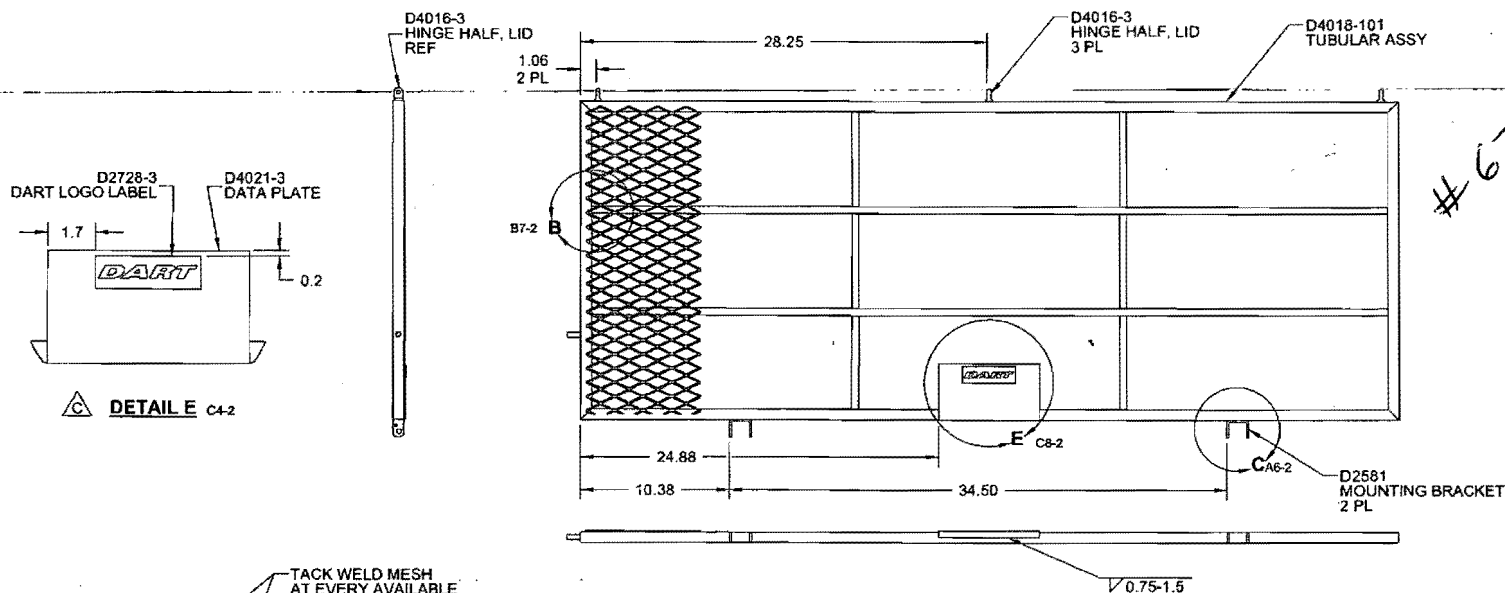
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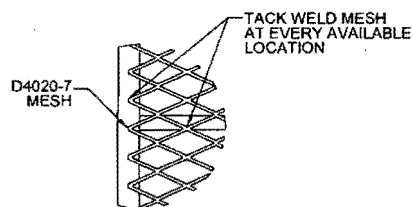
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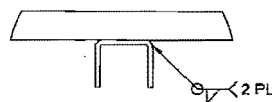
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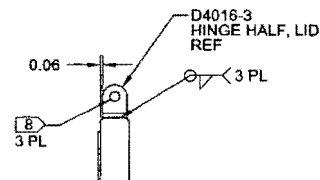
DETAIL E C4-2



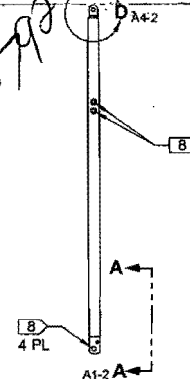
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

RELEASED
10.08.12

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D4018	REV. C
CHECKED	SC		SHEET 2 OF 4
MFG. APPR.	AS	TITLE SHORT BASKET LID ASSY (350)	SCALE NTS
APPROVED	AS		
DE APPR.	AS		
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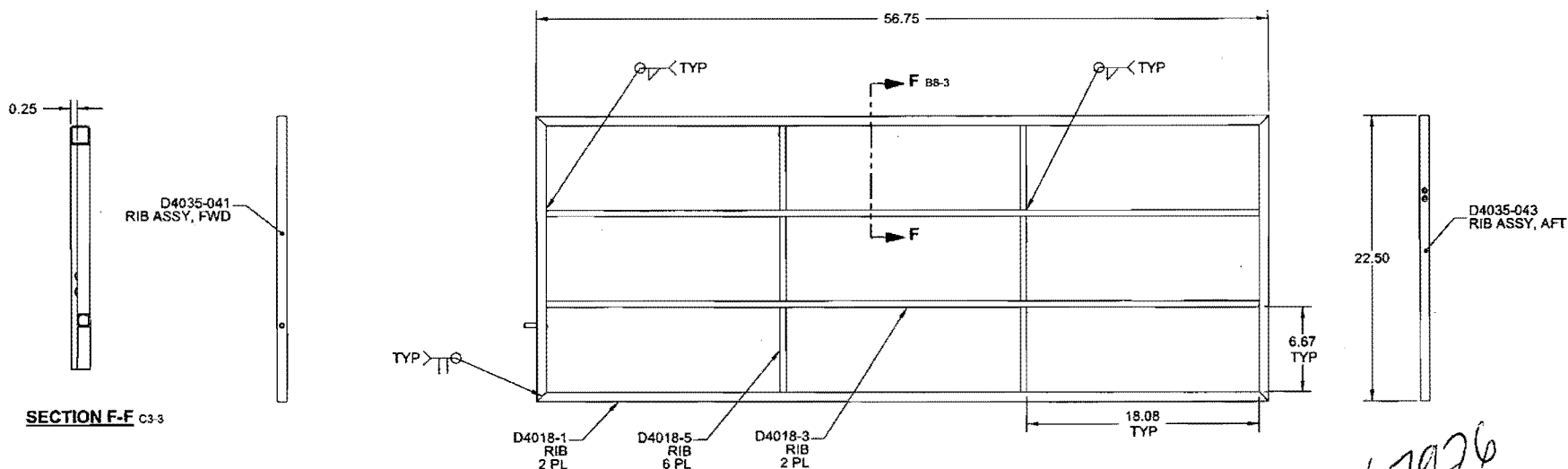
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
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RELEASED
10.08.12 UP

#67926

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

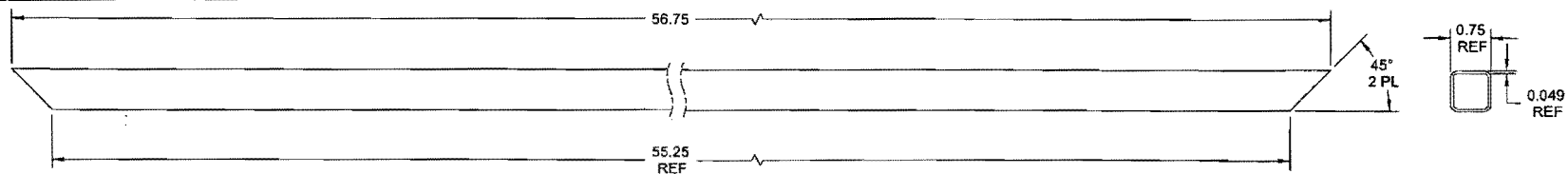
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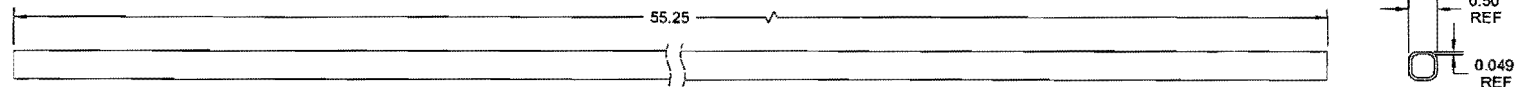
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

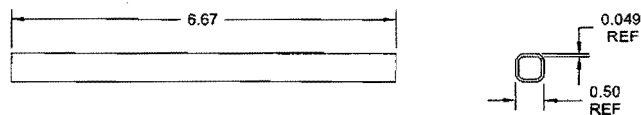
D



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

67926

RELEASED
10.08.12 LP

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	A15	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

A

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